

# Work Order ID 71636

Thursday, July 07, 2011 11:22:40 AM



Page 1

Item ID:	D3255-1	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	Panel					
Start Date:	7/7/2011	Start Qty:	4.00			
Required Date:	7/21/2011	Req'd Qty:	4.00			
Reference:						

Approvals:	Process Plan:	<u>MF</u>	Date:	<u>11-07-07</u>	Tooling:		Date:		Run	Start	
	QC:		Date:		SPC (Y/N):		Date:			Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3255	Rev B								

100		0.00							
	FLOW WATER JET								
Waterjet	Memo	0.00							
FLOW CNC Waterjet	1-Cut as per Dwg D3255 <input type="checkbox"/> Dwg Rev: <u>B</u> <input type="checkbox"/> Prog Rev: <u>B</u> <input type="checkbox"/> 2-								
<u>304.032</u>	Deburr if necessary								<u>HB 10-8-10</u>

110		0.00							
	QC2- Inspect parts off machine FAI/FAIB								
QC	Memo	0.00							
Quality Control									<u>HB 11-8-10</u>

120		0.00							
	QC8- Inspect parts - second check								
QC	Memo	0.00							
Quality Control									<u>8 w/08/11</u>

x4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 71636**

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Item ID: D3255-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Panel

Start Date: 7/7/2011 Start Qty: 4.00



Cust Item ID:

Required Date: 7/21/2011 Req'd Qty: 4.00



Customer:

Reference:

Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

130



Brake NC

NC BRAKE

0.00

Brake NC

Memo

Form as per Dwg D3255

0.00

SB 11/08/23

(4)

140



QC

QC5- Inspect part completeness to step on W/O

0.00

Quality Control

Memo

0.00

S 11/08/24

(4)

-1

150



Packaging

Identify as per dwg & Stock Location: WA

0.00

Packaging

Memo

0.00

SP 11-08-24 SJ

W/O:		WORK ORDER CHANGES					
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Item ID: D3255-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Panel

Start Date: 7/7/2011 Start Qty: 4.00



Cust Item ID:

Required Date: 7/21/2011 Req'd Qty: 4.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

160

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/8/24 [Signature]

11/08-24  
(4)

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# Picklist Print

Thursday, July 07, 2011 11:22:37 AM

Page 1

Work Order ID: 71636



Parent Item: D3255-1



Parent Item Name: Panel



Start Date: 7/7/2011

Required Date: 7/21/2011

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev:A New Issue 06-08-01 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S22GA  304/316 .032 Sheet		Purchased	No			100	sf	43.3600	1.484 	6.248421		EB11-8-10	

Location

Loc Qty

Loc Code

020

5.8

109057

5.8

MAT020

37.56

117379

37.56

118400

118400

(4)

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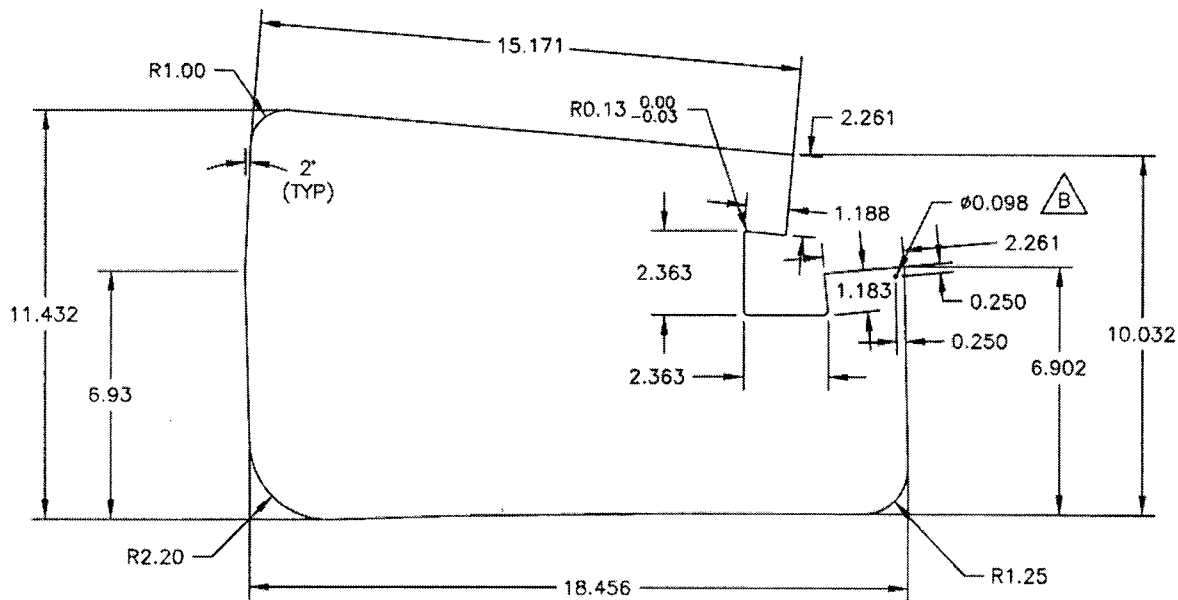






DESIGN RF	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED 4/	APPROVED [Signature]	DRAWING NO. D3255	REV. B SHEET 3 OF 4
DATE 04.12.06		TITLE ACCESS PANEL ASSEMBLY	SCALE 1:5

RELEASED  
05-01-18 [Signature]



**D3255-1/-2 FLAT PATTERN**

**D3255-1/-2 NOTES:**

- 1) MATERIAL: AISI 304/316 SS 0.032 THICK (REF. M304S22GA)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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**Dart Aerospace Ltd**

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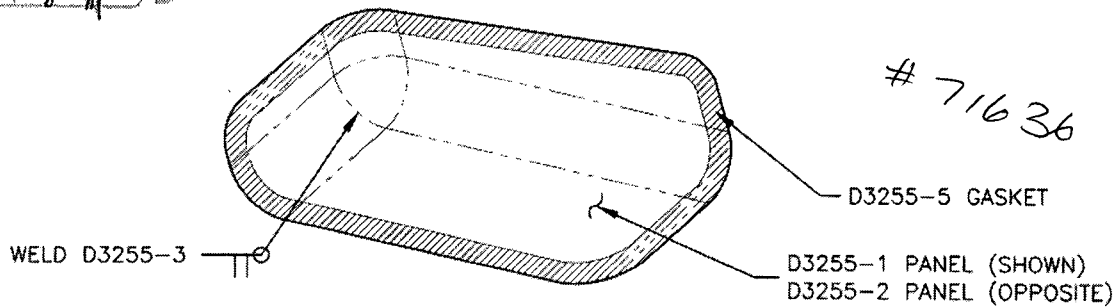
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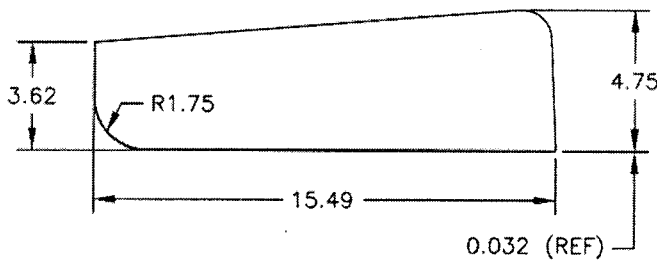
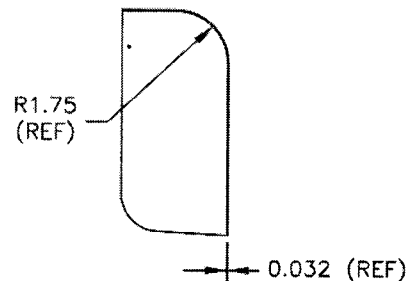
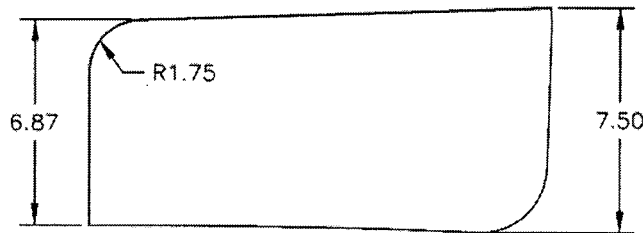


DESIGN TH	DRAWN BY TH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED ip	APPROVED TH	DRAWING NO. D3255	REV. B SHEET 1 OF 4
DATE 04.12.06		TITLE ACCESS PANEL ASSEMBLY	SCALE 1:6
A	04.01.27	NEW ISSUE	
B	04.12.06	D3255-3 REDESIGN; ADDED Ø0.098	

RELEASED  
05-01-18 #



**D3255-041 ACCESS PANEL (SHOWN)**  
**D3255-042 ACCESS PANEL (OPPOSITE)**



**D3255-1 BEND DETAIL**  
**D3255-2 OPPOSITE**

**D3255-041/-042 NOTES:**

- 1) WELD PER DART QSI 004
- 2) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER QSI 005 4.3
- 3) INSTALL D3255-5 GASKET USING DOW CORNING P/N 736 ADHESIVE IN ACCORDANCE WITH MANUFACTURE'S INSTRUCTIONS
- 4) IDENTIFY WITH P/N & B/N USING FINE POINT PERMANENT MARKER

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